

Work Order ID 62711 -2



Page 1

Wednesday, October 06, 2010 3:39:28 PM

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 10/6/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 10-10-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4154

A

0.00



Large Fab

0.00

Large Fab

Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH#: M116399

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH#: M101744

3-Transfer drill holes in bar

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

EL 10-12-22 (X1)

Cpl 10.12.23 (1x)

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Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 10/6/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Small Fab

Small Fab

Memo

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

0.00

0.00

COATED inner surface w Rockguard 4715

M116210

10/12/23

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/12/23

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

PN 64897

0.00

10/12/23

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Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 10/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/23

MF
10-12-23

Picklist Print

Wednesday, October 06, 2010 3:39:33 PM

Page 1

Work Order ID: 62711

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly




Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1  Plate		Manufactured	No			100	Each	4.0000	1	10			

EL 10-12-22 EL

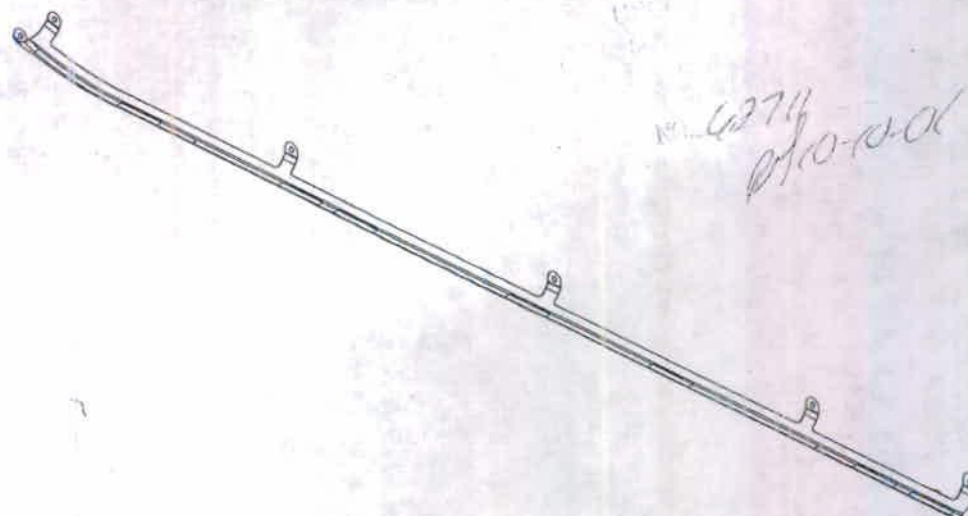
D4155-1  Bar		Manufactured	No			100	Each	5.0000	1	10			
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B62708 *1

Location	Loc Qty	Loc Code
WA	4	
62199	4	
Location	Loc Qty	Loc Code
ST	5	
60976	2	
62198	3	
62709	1	

EL 10-12-22 EL

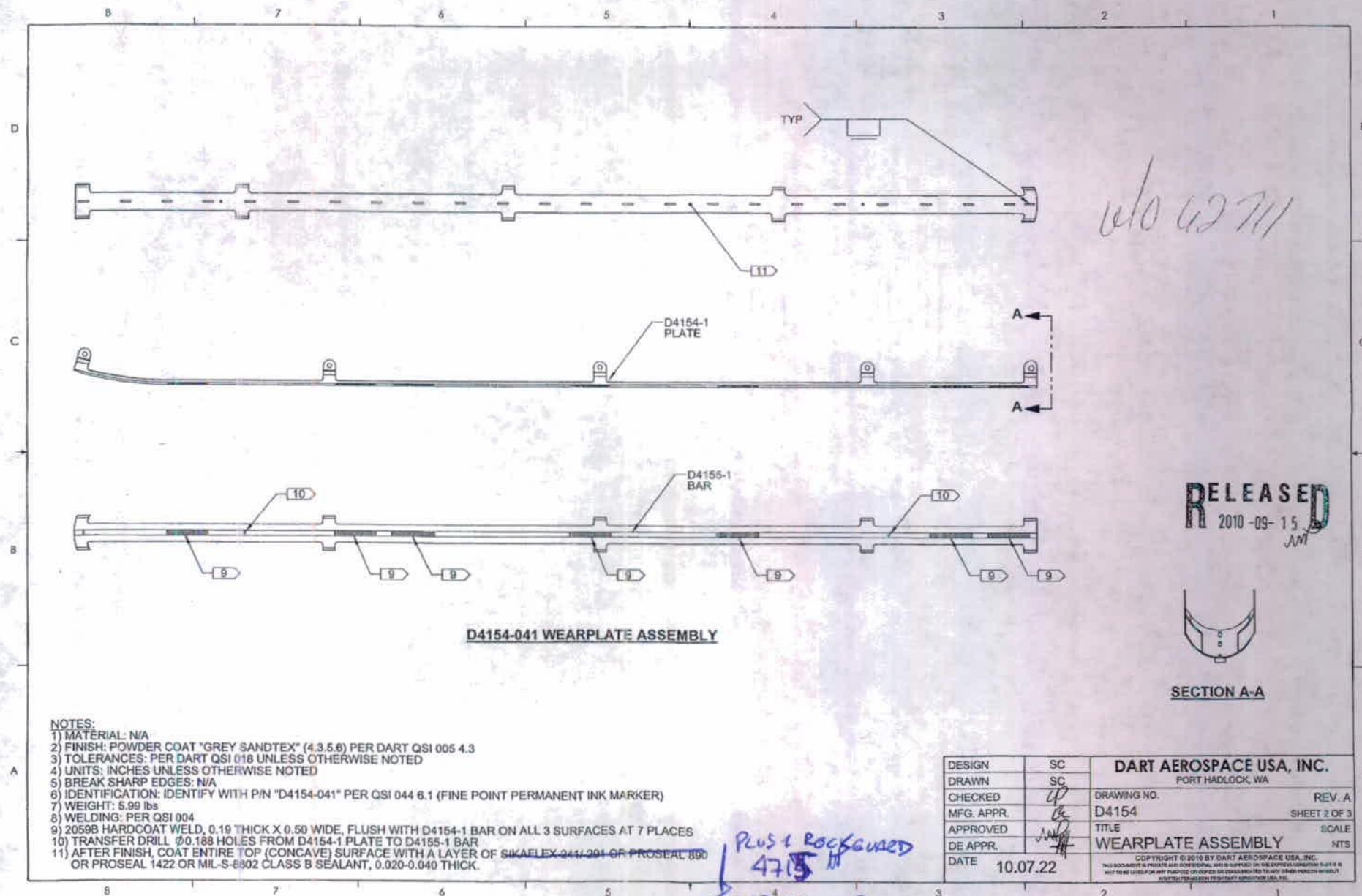
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4154	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2015 BY DART AEROSPACE USA, INC. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE TITLE AND SCALE ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	



RELEASED
 2010-09-15
 JMT

Plus 1 Rock Guard
 4715
 10.12.23 Ref. B63871

B63330
 B62196

